

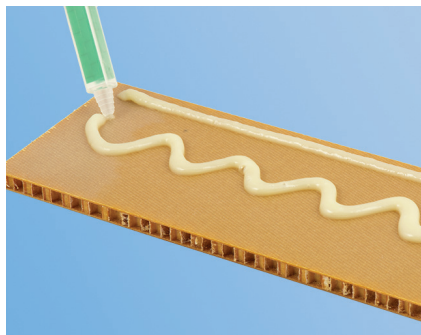
L-9115

FST Room Temperature Cure Adhesive Technology

L&L Products has developed an epoxy-based, FST adhesive for aircraft interiors designed to bond various substrates (metal, thermoplastics and composites) that are common to the aerospace industry.

L-9115 is a two component toughened adhesive which cures at room temperature and provides high performance bonding. It is designed for interior applications and meets the latest FAA fire regulations (vertical burn, smoke density and toxicity).

L-9115 can be supplied in twin-barrel cartridges, pails or drums.



Key Product Attributes

- FST regulation compliant - FAR 25.853, ABD0031
- High strength bonding

Typical Application Areas

- Panel assembly
- Insert bonding
- Bracket bonding

Technical Data

TYPICAL PROPERTIES			
		L-9115	Test Methods
Physical Properties	Color	Off white viscous liquid	
	Working Life	10-20 minutes (10 g)	
	Shore D Hardness (24 hour at 23°C) (73°F)	70	
	Cured Density	1.30 g/cc	
	Mix Ratio	1:1	
Mechanical Properties	Tensile strength on etched Al cured 24 hours at 27°C (81°F)	15MPa (2175 psi)	
	Tensile strength on etched Al cured 2 hours at 65°C (149°F)	24MPa (3500 psi)	
	Tensile strength on BR-127 Primed Al cured 24 hours at 27°C (81°F)	16MPa (2300 psi)	
	Tensile strength on BR-127 Primed Al cured 2 hours at 65°C (149°F)	25MPa (3600 psi)	
Fire Properties	FAA Vertical Burn 12 s	PASS	FAR 25.853 App. F Part I (a) (ii)
	FAA Vertical Burn 60 s	PASS	FAR 25.853 App. F Part I (a) (i)
	FAA Smoke Density	PASS	FAR 25.853 (d) Appendix F, Part V
	Toxicity (Flaming)	PASS	ABD0031, AITM 3-0005, Issue 2

Bonding Process

- Parts should be mated and in final position before the expiration of the working time and should remain in position unstressed and undisturbed until the end of the fixture time has passed.
- Note that working and fixture time are affected by temperature. Elevated temperatures accelerate cure and shorten working and fixture times, whereas lower temperatures slow reaction speed down and lengthen these times. The application temperature for the adhesive and parts should be between 15°C and 30°C (60°F and 85°F).

Shelf Life & Storage Conditions

- Shelf Life: 2 years from date of manufacture when stored at or below 0°C (32°F).
- Long term exposure to elevated temperature can cause the material to lose performance characteristics. Keep away from direct sunlight and all sources of heat and ignition.

- Best results within 1 year if stored between -10°C and 23°C (14°F and 73°F) in original packaging.

Surface Preparation

- The substrates must be clean, dry, and free of dust. Clean surfaces using a general purpose industrial organic solvent. It may be necessary to use an additional surface preparation product (e.g. surface sanding, acid etching for aluminum or primer for thermoplastics) for optimal adhesive behavior.

Health & Safety

- Consult product specific Safety Data Sheet.
- All of our products are developed with REACH compliance.

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